

Date: Tuesday, 5/23/2006 8:12:53 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT
Job Number :	27164		
Estimate Number :	10272		
P.O. Number :	N/A	Part Number :	D2562001
This Issue :	5/23/2006 S.O. No. : N/A	Drawing Number :	D2562 REV D
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	N/A Type : SMALL/MED FAB	Drawing Revision :	D
Previous Run :	25969	Material :	N/A
Written By :		Due Date :	6/4/2006
Checked & Approved By :	<u>JA.06.05.23</u>	Qty:	20 Um: Each
Comment :	Est F 02.04.15 Added dwg Rev.B1 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W035	304 RD Tube .500 x .035W
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Comment: Qty.: 1.7920 f(s)/Unit Total: 17.9204 f(s)
 304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall
 Batch M101593

FF 06.08.08 20

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Punch to length as per Dwg D2562

FF 06.08.08 20

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL/MED FAB RESOURCE
 1- Bend end as per Dwg D2562 Angle "D" SB 04/08/15
 2-Deburr ml 06/05/05

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

JA.06.06 (20)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING
 Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005.4.3

FC 06 09 11 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 26/07/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 27164

Part Number: D2562001

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

106/8/12 20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 3184

RB 06/09/12 20

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DP 06/09/12 20

Job Completion



U 060912

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design.Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

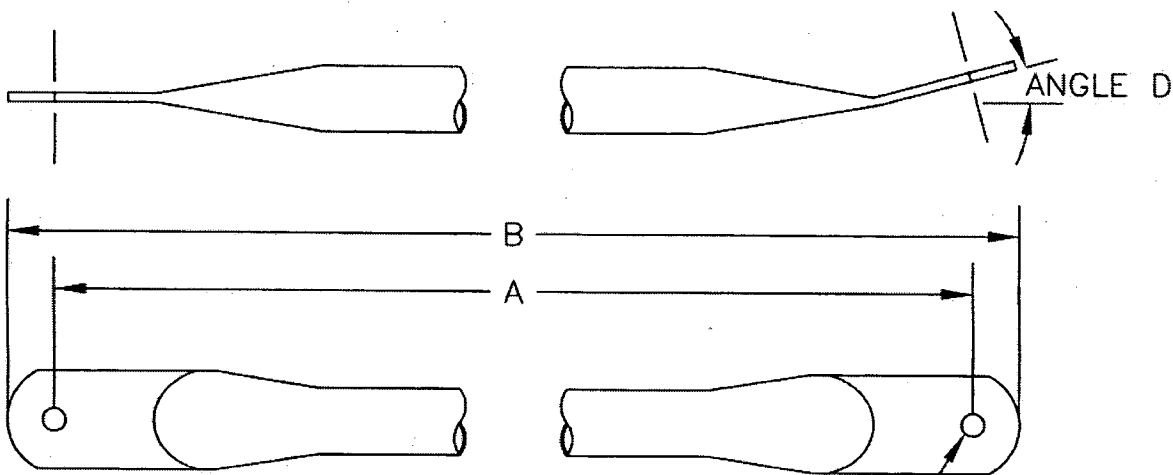
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART

DESIGN		DRAWN BY		DART AEROSPACE LTD	
CP	RF	HAWKESBURY, ONTARIO, CANADA		REV. D	
CHECKED	APPROVED	DRAWING NO.		SHEET 1 OF 1	
RF	RF	D2562		SCALE	
DATE		TITLE		1:2	
05.05.18		STRUT			
A	96.05.01	NEW ISSUE			
B	98.10.15	UPDATED MATERIAL NOTE (TSR A603)			
C	02.06.05	ADD -005; ADD FINISH			
D	05.05.18	ADD -007/-011/-013; UPDATE -005			



PUNCH ENDS PER SPEC CONTROL DRAWING D2727

PART #	DIM A	DIM B	DIA C	ANG D
✓ D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

06.05.27

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 27164

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